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If hydrogen or reducing gases rich in hydrogen are present during welding, hydrogen atoms may go into solution in the metal in amounts which may be several thousand times greater than those in solution at ordinary temperature; The base metal adjacent to the line of fusion occurring at a very high temperature will absorb, by diffusion, quantities of hydrogen several hundred (over)  
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(over)

62-18441

I. Meunier, F.  
II. Sebille, J.

C227744

Office of Technical Services

times greater than those which the metal normally holds in solution at room temperature; Upon cooling, super-saturation will cause precipitation of hydrogen in all discontinuities of the metal (intergranular joints, inclusions, pores, etc.) where it recombines into the molecular insoluble form producing local pressure which may be considerable; The combination of stresses resulting from the pressure of these gas pockets, from thermal contraction and possible martensitic transformation of these semi-special steels may produce permanent deformation and rupture; Localization of these cracks and the fact that they may be eliminated by drying the coating suggests that hydrogen is the principal cause.  
(Author)

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